

Work Order ID 71371 -3

Thursday, June 30, 2011 8:20:13 AM



Page 1

Item ID: D2965

Accept



Setup Start



Revision ID:

Item Name: Cap. 105 Skidtube

Stop



Start Date: 6/30/2011 Start Qty: 50.00

Required Date: 7/15/2011 Req'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: 11/06/30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2965

Rev B

0.00

100



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 14401 Cast per Dwg D2965 Material Release Note Required

CL 11/06/30 50

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

11/14/10 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S. Uloslor

Counts

(452)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No ~~DQA~~: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Page 2

Item ID: D2965

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap. 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Drill as per Dwg D2965 with DT8538 Deburr and Tumble

0.00

0.00

SP11/08/15 (48)

140



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

8 wlog15

counter (48)

150



Powdercoat

powder Coating

Powdercoat

Memo

Mask as per Dwg D2965 Powder To match Skidtube(Ref: 4.3.5.x) as per QSI
005 4.3 START TIME: FINISH TIME: OVEN TEMPERATURE:

0.00

0.00

leave unpainted for black or grey in worst

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Page 3

Item ID: D2965

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap, 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

N/A

0.00

170



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

N/A

0.00

Install Inserts as per Dwg D2965

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

N/A

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Page 4

Item ID: D2965

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap. 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Identify as per dwg & Stock Location: FP-2

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

M 11/09/08 X10

11/9/08 JF

mf 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 30, 2011 8:20:10 AM

Page 1

Work Order ID: 71371

Parent Item: D2965

Parent Item Name: Cap, 105 Skidtube



Start Date: 6/30/2011

Required Date: 7/15/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: A 00.05.31 New Issue EC
IPP Rev: Added Turning as per Rev B 06-12-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 INSERT		Purchased	No	N/A	N	170	Each	700.0000	2	100			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST282		700							
				100896		100							
				111529		300							
				111581		300							
D2965P Cap		Purchased	No			170	Each	0.0000	1	50			

Rev B/05 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

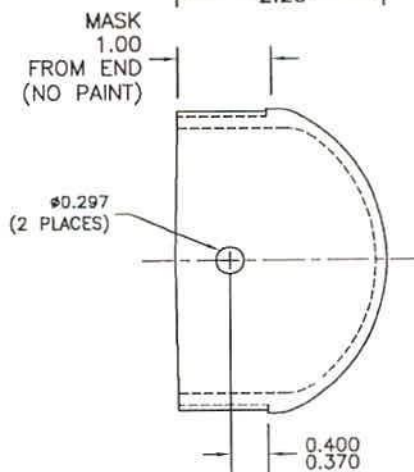
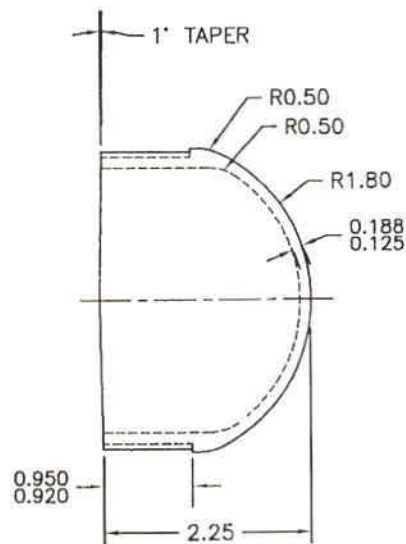
NOTE: Date & initial all entries



RELEASED

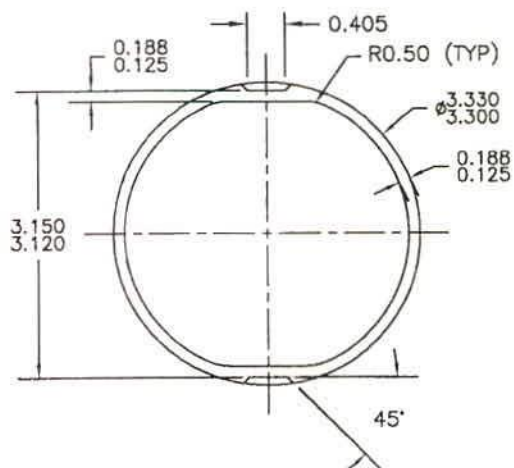
06.12.12

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. B
				D2965	SHEET 1 OF 2
DATE	06.11.01			TITLE	SCALE
				CAP	1:2
A	00.02.24			NEW ISSUE	
B	06.11.01			ADD -3 CAP	

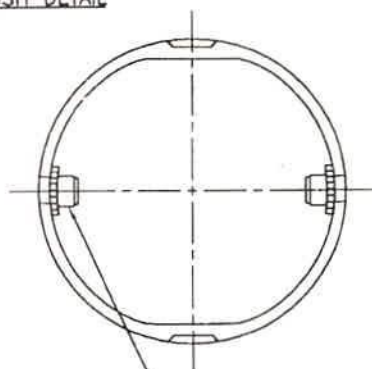


061106130
W10: 71371

D2965 CASTING DETAIL



D2965 FINISH DETAIL



INSTALL AELS-1032-225 INSERT
(2 PLACES)

D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

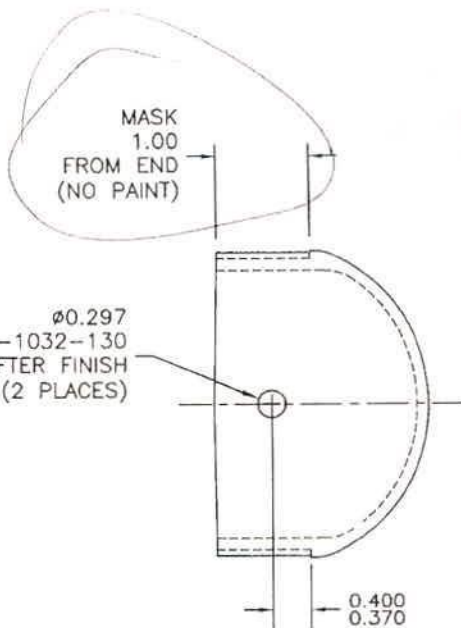
DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

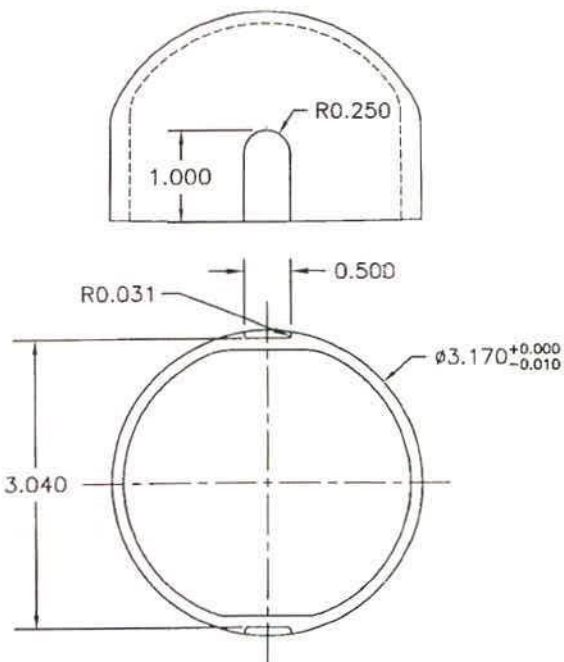
DESIGN	BY	DRAWN BY	DRAWING NO.	REV. B
CHECKED	BY	APPROVED	D2965	SHEET 2 OF 2
DATE	06.11.01	TITLE	CAP	SCALE
				1:2

RELEASED

06.12.02



D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14401

Purchase Order Date 6/30/2011

PO Print Date 6/30/2011

Page Number 1 of 1

Order From : VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 683 9777	Requisition Nbr	
Vendor Fax	514 683 0375	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

REVISED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 1/10/130

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2965P		Cap	7/18/2011 Yes	50.00 Each	FedEx PI collect	\$20.3500	\$1,017.50

Special Inst: CAST AS PER DWG D2965 REV. B
B71371

MATERIAL: CAST ALUMINUM
ALLOY A356.2 (F)

PO Total: \$1,017.50

MATERIAL CERTIFICATION
REQD UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 6/30/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Aluminum Foundry Ltd

2225 Chemin St. Francois

Dorval, Québec H9P 1K3

Tel: (514) 683-9777

Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.:

33764

Shipped Date:

03 08 2011

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 14401	
Shipped By:	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z200080	Each	D2965 CAP	50
<div>Received by:</div> <div>Date:</div>			
Comment:			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD2225 CHEMIN ST. FRANCOIS, DORVAL, QC H9P-1k3
TEL : (514) 683-9777 FAX: (514) 683-0375Attn. Chantal
Corrected
addressExpédié à
Shipped

DART AEROSPACE

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Date: 03/08/2011

Packing

Slip No.

33764

Hawksbury, ON, K6A 1K7

Vôtre No. Commande

14401

Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
50	D 2965 CAP Sulcor	Z200080	A356.2	ingot#855862 B# 1120401

Analyse
Analysis (as in ingot)

(Si)	7.1%	(Al)	balance
(Fe)	0.09%		
(Cu)	0.03%		
(Mn)	0.00%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield :Résistance a la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

70 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Date: 03/08/2011 Packing Slip No. 33764

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 14401
Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
50	D 2965 CAP	Z200080	A356.2	Ingot#855862 B# 1120401

Analyse
Analysis (as in Ingot)

(Si)	7.1%	(Al)	balance
(Fe)	0.09%		
(Cu)	0.03%		
(Mn)	0.00%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield:Résistance à la tension :
Tensile Strength:Allongement par pouce carré :
P.S.I. Elongation:

%

Pour et au nom de
For and on behalf of:FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Coc-100

Dept/Dep :
Par/Per :

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries